Work Orde May-01-13 7:29			1		*	1008	364	_*	· · ·						Page 1	
Revision ID:	D3182- Hinge	1			Accept	3	*Nº	ากก	040	100)*	Setup	Start Stop	ı VI -	S1*	
Start Date:	4/30/13	Sta	rt Qty: 4.00	*4*			Cus	t Item I	D:					1 14		
Required Date:	4/30/13	Rec	ı'd Qty: 4.00	*4*				tomer:								
Reference:			4	_												
Approvals:	Proces	s Plan:	MUS	Date: 13-05-03	Tooling	j :		Da	ate:	_		Run	Start	17	R1*	
									ate:				Stop	*N	R2*	
Sequence ID/ Work Center ID)		ration cription		Set U Run	Jp/ Hours	To	ool ID	Tool #	Plan Code	Accept Qty	t R	eject ty	Reject Number	Insp. Stamp	
Draw Nbr		Revision	Nbr								· · · · · · · · · · · · · · · · · · ·		***			
D3182		Rev A	,													
100		FLO	W WATER JET		0.00						السا		0		JmB-1	2
Waterjet			Memo		0.00	A									3,772	
FLOW CNC Waterje	t		1-Cut as pe Deburr if no	r Dwg D3182 Dwg Rev: ecessary	/ Pro	g Rev: A	_ 2-								4	
<u> </u>		QC2	- Inspect parts off n	nachine FAI/FAIB	0.00											
*11 0 *			Memo		0.00	÷					4	<u></u>	0		Jm13-18) -
Quality Control																
						DAS 27										
120		QC8	- Inspect parts - sec	ond check	0.00	9-89	_ବ				4					
120 QC Quality Control			Memo		0.00	RIDI	U]									

	1									DQA:	Date	::
NCR: Ye	es / No				WORK ORDER NON-	CON	IFORM	ANCE / UPI	DATE	OA Clased:	Data	
	· · · · · · · · · · · · · · · · · · ·				T					QA Closed:	Date	
Work Order	:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No	D				Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	D				Work Order Update]		Large Fab	Composite		Supplier	
Root	:			Descri	ption of work order update	Ir	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Descr	ription	Date	Verification	QC Inspector
Ooc/Data												
quip/Tooling						1						
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etup						1						
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raining [
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Landing	g Gear				General					_		
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L	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
L	Cracks			<u></u>	Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		•
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Orde <i>May-01-13 7:29</i>		100864		*100	1864*						Page 2
Revision ID:	D3182-1 Hinge			Accept	*N900	 1040	100)* s	Setup Star Sto	I VI	S1* S2*
Start Date: Required Date:	4/30/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item						. 1/
Reference: Approvals:		Plan:	Date:	Tooling: SPC (Y/N):		Date:		F	Run Stai	" [V]	R1* R2*
Sequence ID/ Work Center II 130 *1 3 0 *1 3 0 * 1 4 0 *1 4 0 *1 4 0	D	Operation Description Small Fab Memo Debur if new	cessary eteless to step on W/O	Set Up/ Run Hours 0.00 0.00 27		Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
QC Quality Control 150 *150* Packaging Packaging		Memo	ock Location: WACO K IN BASKET CELL****	0.00			,		DAS 28 9-89	13-1	2-9_

NCR: Y	es /	No				WORK ORDER NON-O	CONF	ORI	MANCE / UP	DATE			
		'									QA Closed:	Date	•
Work Orde	er:	l				DISPOSITION	_			AGAINST D	EPARTMENT,	/PROCESS	
Part N						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	→	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T	•			Descri	ption of work order update	Ini	tial	Act	tion	Sign &		
Cause	D	ate	Step	Qty	,	or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
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Landi	ng Gear	:				General					_	<u></u>	
	Cen Cras Crus Cuff Hea Insp	cks shed/(s t Trea	n Strip in		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		struct	ion Incomplete tions Incomplete/l enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	_ `		aves in E	Extrusio	n	Drawing	-		Calibration				
	_		equence			Finish	П	ut of	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

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Work Ord <i>May-01-13 7:2</i>		100864		*100	1864*		· · ·				Page (3
Item ID: Revision ID:	D3182-1			Accept	*N900	0401 0) 0*	Setup	Start	*N	S1*	
Item Name:	Hinge								Stop	*N	S2*	
Start Date:	4/30/13	Start Qty: 4.00	*4*		Cust Item I	D:						
Required Date	e: 4/30/13	Req'd Qty: 4.00	*4*		Customer:							
Reference:								Run	Start	ala B. II	— 4 +	1.
-Approvals:	Process	Plan:	Date:	Tooling:	Da	nte:		Kun		*N	R1*	
	QC:	· · ·	Date:	SPC (Y/N):	Da	nte:			Stop	*N	R2*	
Sequence ID/ Work Center	ID	Operation Description	18 ·	Set Up/ Run Hours	Tool ID	Tool # Pla Coo	-	pt Re	-	Reject Number	Insp. Stamp	
*160, *160*		QC21- Final Inspection	Work Order Release	0.00			Jb.)/L	W	13/12/	110	;
QC Quality Control		Memo		0.00			97	<i>//</i>				- ! -:

MB10.02

		1										DQA:	D	ate:	
NCR:	Yes	/ No :				WORK ORDER NON-	COF	VFORM	MANCE / UP	DATE				,	
											QA C	losed:	D	ate:	
Work Ord	er.	1				DISPOSITION				AGAINST DE	PART	MENT	/PROCESS		
Part I	•					Rework Scrap Use-as-is		,	Skid-tube Machining	Crosstube Small Fab Finishing	Ré		Water Je d. Eng. Coor re/Packaging		Engineering Quality Other
NCR I	No.	· · · · · · · · · · · · · · · · · · ·				Work Order Update			Large Fab	Composite			Supplie	_	
Root					Descri	ption of work order update		Initial	Ac	tion	Sig	n &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	D	ate	Verification	on	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material							ļ								
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
		:	·			F	AUI	LT CATE	GORY						
Landi	ing (Gear				General		_			_				
		Bending				Bend		Grain			Ovali	zed			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over,	/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete]Part i	ncorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	'Unclear	Part I	_ost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part I	Moved			-
		Heat Trea	at			Countersink		Mislabe	eled		Posit	ioned \	V rong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Powe	r Loss/	'Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Picklist Print

May-01-13 7:29:40 AM

Page 1

Work Order ID:

100864

Parent Item:

D3182-1

Parent Item Name:

Hinge

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A03.01.29New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	!
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	184.8300	0.0596	9 .25094 72 © .5			Jm13-12-	7

Location	Loc Qty	Loc Code	
MAT020	184.83		
122521	24.93		
124445	159.9		

126075

126075

NCR: Y	res / No) '			WORK ORDER NON-C	COP	MFORM	/IANCE / UP	DATE'				
										QA Closed:	Dat	:e:	
Work Orde	eŕ:	!		-	DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS		
Part N					Rework Scrap Use-as-is		r	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Eng	gineering Quality Other
NCR N	No				Work Order Update]		Large Fab	Composite]	Supplier		
Root		T		Descri	ption of work order update		nitial	Ac	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	<u>1 C</u>	QC Inspector
Doc/Data Equip/Tooling		:											
Operator													
Material			:			1				1			
Setup		1											
Other]										
Process						1							
Supplier												į	
Training													
Unapproved												İ	
	•	-			F	AUL	T CATE	GORY					
Landi	ng Gear	:			General		_				_		
	Bendin	g			Bend		Grain			Ovalized		Press	ure/Forced
	Centre	Not Conce	entric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temr	perature/Cure
	Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorre	ct	Weld	ı
	Crushe	d/Crimped	İ		Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wror	ng Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved	•		
	Heat T	reat			Countersink		Mislabe	led		Positioned V	Vrong		
	Inspect	tion Strip ir	n Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Othe	r
	Ripples	in Bend			Drill Holes		Offset				·		
	Torons	Waves in	Extrusio	, F	Drawing		Out of C	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date: ___

Turning Sequence

Wave/Twist in Tube

Finish

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Order: 1008(0)	[
Number: D3182-	·1
	Page 1 o

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

					,	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.718	+/-0.010	3.718"	_		U	
Ø0.257	+0.006/-0.001	0.258"	_		V	
2.304	+/-0.010	2.304"			J	
R0.125	+/-0.010	0.125° 2.304° 0.258"	_	,	RG	
					77.05	
					- · · · · · · · · · · · · · · · · · · ·	
					<u> </u>	
						!
			· · · · · · · · · · · · · · · · · · ·			
			DAS			

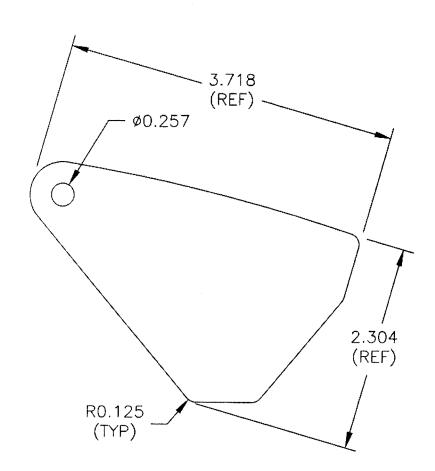
Measured by:	Audited by:	9-89 ₁	Prototype Approval:	N/A
Date: (3-12-7	Date:	13/12/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM	
В	08.01.16	3.718 was 3.178	KJ/EC/DD	3





DESIGN 4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO. D3182	REV. A SHEET 1 OF 1	
DATE		TITLE	SCALE	
03.01.21		HINGE	1:1	
A	03.01.21	NEW ISSUE		



D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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